	ID 115180 7, 2014 2:49:52 PM		*11!	5180) *							Page 1
Revision ID:	03535-11 tainless Steel Wearplate Fwd		Accept	*N	900	<u>040</u>	100)*	Setup	Start Stop	1/1	S1* S2*
Start Date: 3, Required Date: 3, Reference:	/17/14 Start Qty: 18.0 /17/14 Req'd Qty: 18.0				st Item l stomer:	D:						
	Process Plan: QC:	Date: 1403-19				ate:			Run	Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Ţ	ool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr											
D3535	Rev B		0.00				<u> </u>		at the same of the			
100 Waterjet FLOW CNC Waterjet 304 . 040.	FLOW WATER JET Memo 1-Cut as Deburr i	per Dwg D3535 Dwg Rev: f necessary	B 0.00 Prog Rev:	<u>B</u> 2-				26	0			JM14-03.36
110	QC2- Inspect parts o	ff machine FAI/FAIB	0.00	مستسيرته يوبينان				,				
110 QC Quality Control	Memo		0.00					200	0		•	Jm14-03,30
120 *120* QC Quality Control	QC8- Inspect parts -	second check	0.00 P	0AS 27 -09 /3/				26	· .			

DQA:			. Date:						•				_	$\mathbb{T} \mathbb{Q} \mathbb{A} \mathbb{C}^{\mathcal{L}}$
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	۱۸/	ork Order u	odate only [_	AEROSPACE
Government.			Dute.											
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
					_	Rework			Skid-tube Crosstube		1	Water Jet	\neg	Engineering
Part N	۱o.					Scrap		!	Machining Small Fab	-	Pro	d. Eng. Coor.	7	Quality
						Use-as-is		Thern	noforming Finishing	;[Rec/Sto	re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab Composite	L	_	Supplier		
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		Centre No	ot Concen	tric		BOM/Route		Grain			Over/Under	tolerance		et-up
		Cracks			1	Broken/Damage/Defect		Hardwa	ire		Part Incorred	a F		emperature/Cure
		Crimp/Kir	k/Ripple/	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	J۷	Veld
		Cuffs	,	مسمسم		Contamination		Instruct	tions Incomplete/Unclear		Part Moved		J۷	Vrong Stock Pulled
		Crushing	and a second		. [Countersink		Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	0	ther
		Inspection	n Strip in [.]	Tube		Drawing		Misread	d					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of 0	Calibration					. 7g ±.,,q.,,q.
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Work Ord Monday, March				*115	180)*			•				Page 2	
Item ID: Revision ID: Item Name:	D3535-11 Stainless Stee	el Wearplate Fwd		Accept	*N:	የበበ	040	10	N *	Setup	Start Stop	*N	S1* S2*	
Start Date: Required Date: Reference:	3/17/14	Start Qty: 18.00 Req'd Qty: 18.00	*18* *18*			t Item I tomer:	D:						. 1/	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):			ate:	<u> </u>		Run	Start Stop	*N	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	То	ol ID	Tool#	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp	DAS
120 Brake NC Brake NC			rake as per Dwg D3535 us Dwg D3535 using Jig DT6						26×	<u> </u>			14/04/01	36 9-89
140 *1 4 \^* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00 DAS 27 9.89 0.00 MU	J				26					

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150 Powdercoat

Powder Coating

Memo

START TIME: \(\sum_{\text{sinish}}\)

FINISH TIME:

26 6 14-4-2 35.8

DQA:			Date:										•	
QA Closed:			Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / U		ork Order up	odate only	\neg	AEROSPACE
Work Orde	ar.					DISPOSITION					PARTMENT	•		
WOIK Olde	۲۱۰.					Rework	1		Skid-tube	Crosstube	7	Water Jet	—	Engineering
Part N	No.					Scrap			Machining Machining	Small Fab	- Pro	d. Eng. Coor.	\dashv	Engineering Quality
	•					Use-as-is			noforming	Finishing	-	e/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite]	Supplier		
Root					Desc	ription of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	<u>1</u>	QC Inspector
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Landi	ng (1			_	General		1		_	7	. г		
	<u> </u>	Bending				Bend	<u> </u>	4	rogram		Outside Dim	- -		Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		_	Over/Under	F		Set-up
	_	Cracks		4	-	Broken/Damage/Defect		Hardwa			Part Incorred	.		Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Rippie	/Wave	\vdash	Burrs		1	ion Incomplete/U	· —	Part Lost/Mi	· ·		Weld
		Cuffs			-	Contamination	_	4	ions Incomplete/l	Unclear	Part Moved			Wrong Stock Pulled
	\vdash	Crushing			-	Countersink	<u> </u>	┫ -	ned/off center		Positioned V		—	اما
	\vdash	Heat Trea		T L	\vdash	Cut Too Short	<u> </u>	Mislabe		<u>L</u>	Power Loss/	Surge		Other
	\vdash	Inspectio	•	rube	<u> </u>	Drawing	\vdash	Misread						
	_	Marks/Ch			\vdash	Drill Holes	\vdash	Off-set					_	
	_	Turning S			<u> </u>	Finish	<u> </u>	-	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

Work Orde				*115	180)*	<u>.</u>			· · · · · · · · · · · · · · · · · · ·			Page 3	=
Item ID: Revision ID: Item Name:	D3535-11 Stainless Stee	el Wearplate Fwd		Accept	*Nc	300	<u>0</u> 40	10	n *	Setup	Start Stop		S1* S2*	-
Start Date: Required Date: Reference:	3/17/14 3/17/14	Start Qty: 18.00 Req'd Qty: 18.00	*18* *18*			t Item l tomer:	ID:							
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):			ate:			Run	Start Stop	^I\I	R1* R2*	
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 27 9-89	То	ol ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
170 *170* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location: F72-661	0.00					X26)	4	lll	14/0	?.d
180		QC21- Final Inspection -	Work Order Release	0.00										

0.00

Memo

1 RN

Quality Control

MUJ 140402

DQA:			Date:											abla
OA Classida			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD				_	AEROSPACE
QA Closed:			Date:				_			W	ork Order up	date only	ل	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	\Box	Quality
	-					Use-as-is			noforming	Finishing	-	e/Packaging		Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite		Supplier		
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Root	}				Desci	ription of work order update		nitial	Action		Sign &			,
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	<u> </u>	QC Inspector
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Landi	ng G	ear				General		•			-			
	_	Bending				Bend		Folio/F	Program	<u> </u>	Outside Dim	ensions	Ш	Pressure/Forced
		Centre No	ot Concen	ntric		BOM/Route		Grain		L.	Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect	L	Hardwa	are		Part Incorred	ાં		Temperature/Cure
		Crimp/Kir	ık/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing		Weld
		Cuffs			L	Contamination		Instruct	tions Incomplete/Unc	clear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong .		
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspection	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Picklist Print

Monday, March 17, 2014 2:49:51 PM

Work Order ID: 115180

D3535-11

Parent Item Name: Stainless Steel Wearplate Fwd

115180

D3535-11

Start Date: 3/17/14

Required Date: 3/17/14

Start Oty: 18.00

Required Qty: 18.00

Page 1

Comments:

Parent Item:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304S20GA		Purchased	No		,	100	sf	352.9019	0.7015	1 3،291 58	3	
M304S20 304/316 .040 Sheet	NGA								**	14		Jm14-03-30
				Location		Loc (Qty	Loc Code				
				MAT020		352.9018	8948					
					m126852		0.91		_			
					m127454	60.3518	3948		_			

4.4

287.24

m128315

m128435

DQA:			Date:											abla
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	odate only	_	AEROSPACE
			-			DISPOSITION				AGAINST DE	•		_	
Work Orde	er: .								a		1		—	\square
Part N	۱o. ِ			···		Rework Scrap		ř	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.		Engineering Quality
NCR I	۱o. ِ					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier		Other
Root					Desc	ription of work order update		nitial	Acti	on	Sign &		\neg	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	,	QC Inspector
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Equip/Tooling														
Handling/Pre														
Material													ļ	
Operator														
Offset/Setup														
Process														
Supplier							ŀ							
Training														
Transport						•								
Unapproved														
							FA	ULT CA	regory					
Landi	ng G	Gear				General		_			_	_		
		Bending				Bend		Folio/F	rogram		Outside Dim	ensions [Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance [Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	:i [Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		instruct	tions Incomplete/U	nclear	Part Moved	Γ	\neg	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	vrong _		•
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	\Box	Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
:		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	115180
Description: Wearshoe	Part Number:	D3535-11
Inspection Dwg: D3535 Rev: B		Page 1 of 1

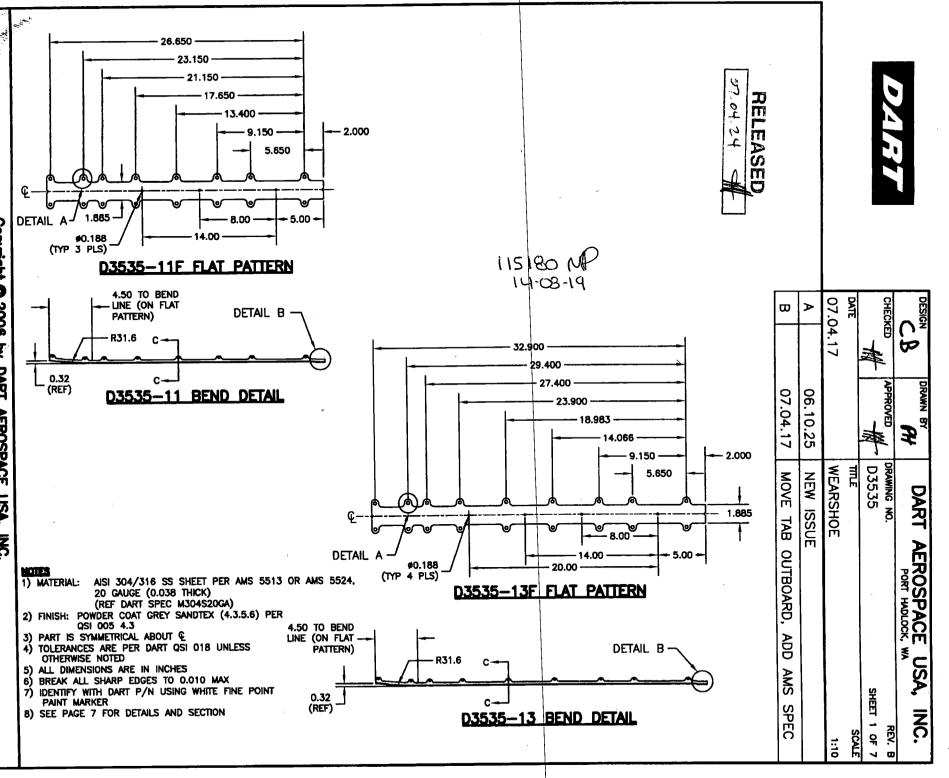
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.010	5.005			U	Jemos
8.00	+/-0.010	8.003"	_		ν	
14.00	+/-0.010	14.00	_		Ť	JEMO7
21.150	+/-0.010	21.150"			+	
26.650	+/-0.010	26.650			T	
5.650	+/-0.010	5.653			V	
Ø0.188	+0.005/-0.001	6.190			V	
0.300	+/-0.010	0.302	_		V	
0.300	+/-0.010	0.303			V	
0.038	+/-0.010	0.039	-		V	
				<u> </u>		

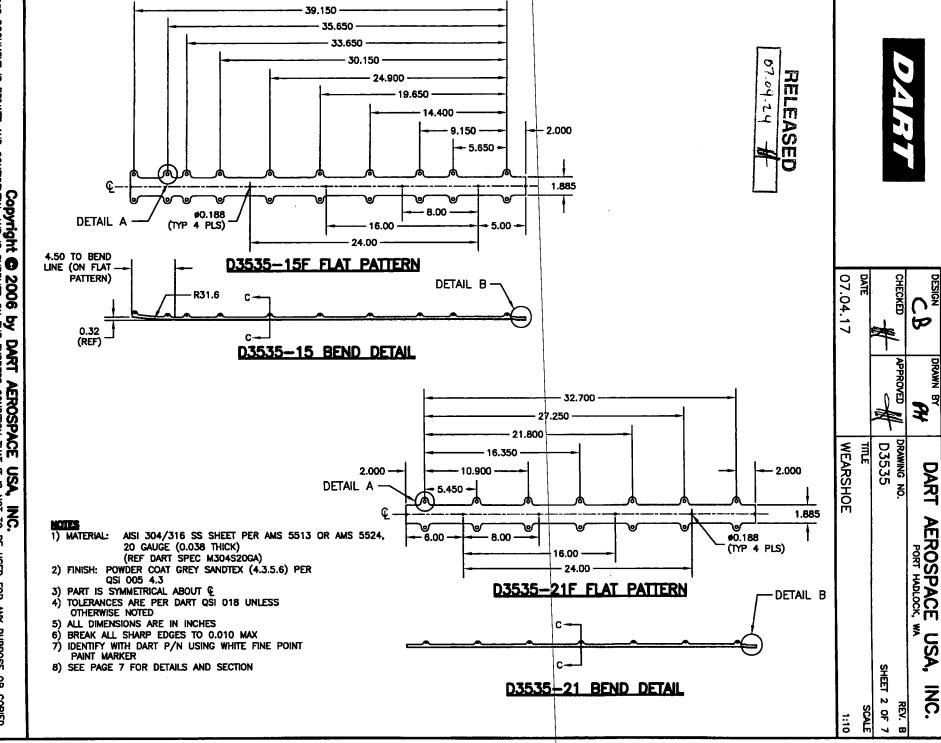
			UAS		
Measured by:	Pho	Audited by:	l	Prototype Approval:	N/A
Date:		Date:	9-69-21	Date:	N/A
	M-02.20		└ <i>╂┪╂╡╂╛/</i> ───		

Rev	Date	Change	Revised by	Approved
Α	09.05.07	New Issue	KJ/DD 4	14



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07.04.17

1:10

h2:h0:10 RELEASE

D3535-31 BEND DETAIL

D3535-31F FLAT PATTERN

22.500 19,000

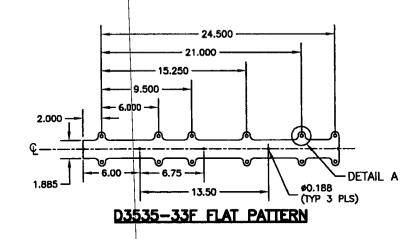
> DETAIL A #0.188 (TYP 3 PLS)

14.250

6.000 -

2.000

1.885



D3535-33 BEND DETAIL

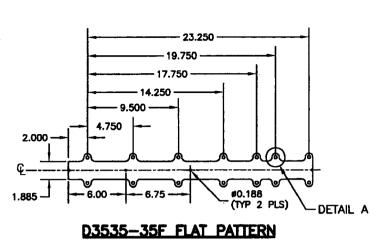
AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA) 1) MATERIAL:

- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

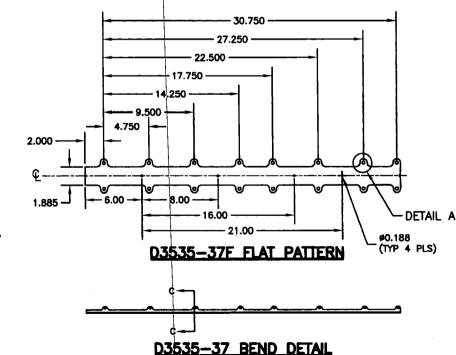
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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

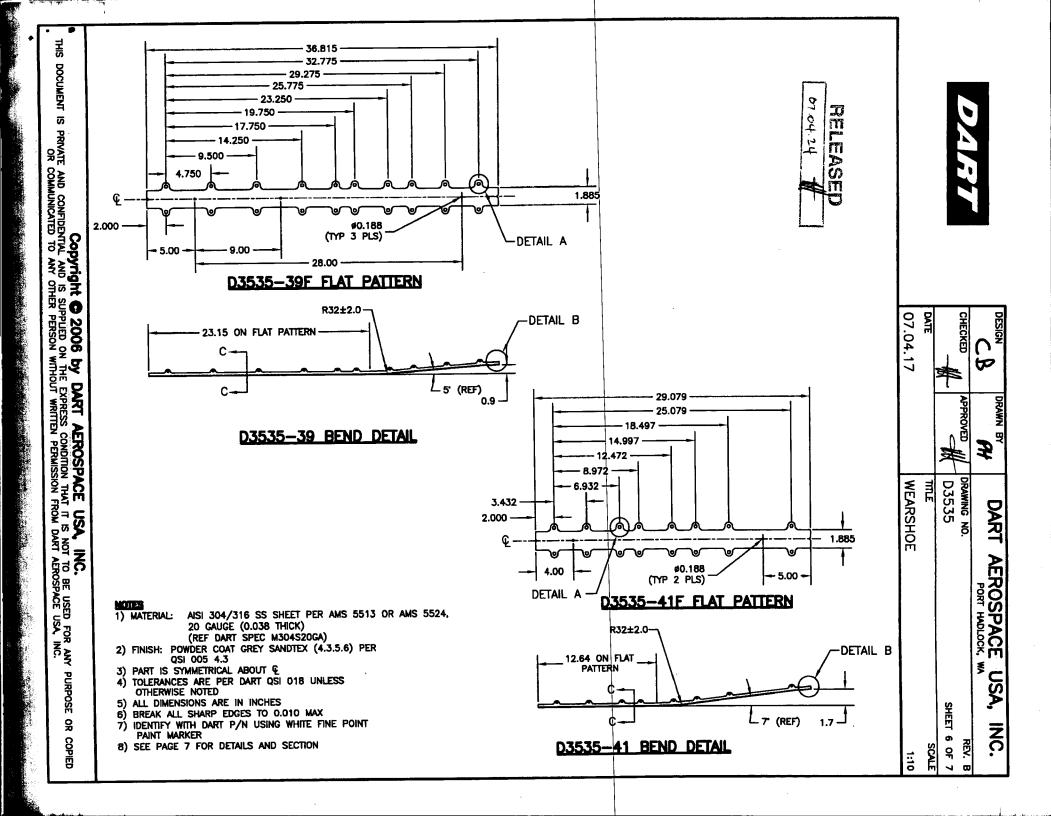
8) SEE PAGE 7 FOR DETAILS AND SECTION

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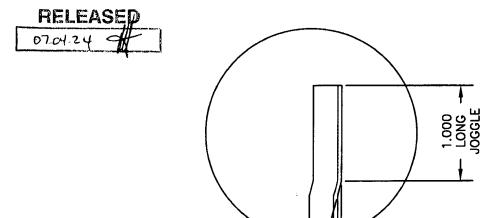
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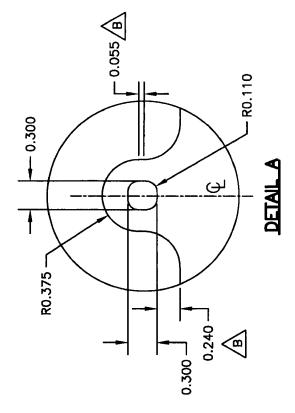
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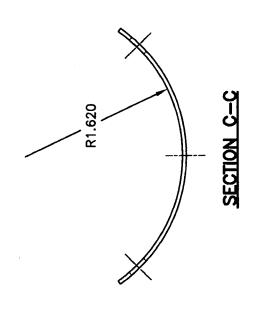




ČB DART AEROSPACE USA, INC. PH CHECKED APPROVED DRAWING NO. D3535 SHEET 7 OF 7 DATE TITLE SCALE 07.04.17 **WEARSHOE** 1:1







0.040 JOGGLE

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